

# Work Order ID 65393

January 14, 2011 12:41:39 PM

Page 1

PRELIMINARY ISSUE

Item ID: D4315-1  
Revision ID: PRELIM  
Item Name: Intake Scoop

Accept

Setup Start

Stop

Start Date: 1/14/11 Start Qty: 1.00  
Required Date: 1/14/11 Req'd Qty: 1.00

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4315	PA3

100	HAND FINISHING THERMOFORMING	0.00
Thermoform	Memo	0.00
Thermoforming Machine	Cut Blanks	

71 \_\_\_\_\_ Dh.  
11/01/13

105	HandThermo	0.00
Hand Finishing Thermoforming	Memo	0.00
	Dry Sheet as per QS1022 Polycarbonate	

\_\_\_\_\_ Dh.  
11/01/13

Temp: 240°F  
Time IN: 4:00 pm 11/01/12.  
Time OUT: 7:00 am 11/01/13

\_\_\_\_\_

Page 2

**Accept**

\_\_\_\_\_

**Setup Start**

**Stop**

[illegible]**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start



**Stop**

**Insp.  
Stamp**

0.00



## THERMOFORMING MACHINE

0.00

## Thermoform

### Thermoforming Machine

## Memo

Thermoform D4315-1 and Flat Panel  
as per Dwg. D4315-1 Preliminary and Folio FTA 096

Dwg. Rev. PRELIMINARY  
Folio Rev. A

120

0.00

\_\_\_\_\_

QC2- Inspect parts off machine FAI/FAIB

0.00

OC

## Quality Control

## Memo

130

0.00

[illegible]

## HAND FINISHING THERMOFORMING

0.00

## Thermoform

### Thermoforming Machine

## Memo

Trim Part D4315-1 and Flat panel parts for Assembly

# Work Order ID 65393

January 14, 2011 12:41:40 PM



Page 3

Item ID:	D4315-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Intake Scoop					
Start Date:	1/14/11	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/14/11	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	HAND FINISHING THERMORORMING	0.00							
HandThermo	Memo	0.00							<i>DL</i>
Hand Finishing Thermoforming	1-Mark and drill D4315-1								<i>11/01/14</i>
	2-Clamp D4315-1 and flat panel so that outside perimeters are mated and transfer drill.								<i>PTO.</i>
	3- Bolt parts together if required								
150 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							<i>DL</i>
Quality Control									<i>11/01/14</i>
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*N/A. Not needed for this order*

*-inspect to PA3*

*Dy. only*  
*Drill only*

Dart Aerospace Ltd

W/O: 65393		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/14	140.	Part not drilled or assembled as per customer request	gk	11/01/14	1	AP 11/01/13	S 11/01/14

Part No: D4315-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 65393

January 14, 2011 12:41:40 PM



Page 4

Item ID: D4315-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Intake Scoop

Stop



Start Date: 1/14/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

Packaging

11/11 145

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

FOR TESTING (TO BE SCRAPPED AFTER)

POSITIVE RECALL

EFFECTIVE 1/14/11 AUTH W

RELEASED 1/14/11 DATE 1/14/11

RD 1332

W 11.01.17

# Picklist Print

January 14, 2011 12:41:37 PM

Page 1

Work Order ID: 65393



Parent Item: D4315-1



Parent Item Name: Intake Scoop

Start Date: 1/14/11

Required Date: 1/14/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 11/01/14 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	3,561.803	13.125	13.125			



GE PLASTICS LEXAN SHEET



Location

MAT

Loc Qty

3561.8038

Loc Code

115261

905.8038

116236

2656

13.125 sq ft

Pl.  
11/01/13

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 65393
<b>Description:</b> Intake Scoop	<b>Part Number:</b> D4315-1
<b>Inspection Dwg:</b> D4315-1 Rev: PA 3	<b>Page 1 of 1</b>

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> Dh-	<b>Date:</b> 10/01/14
-------------------------	-----------------------

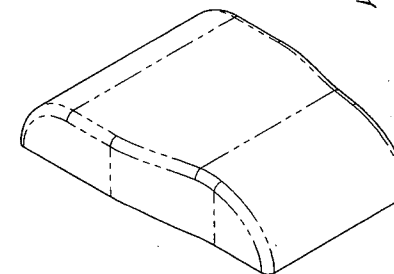
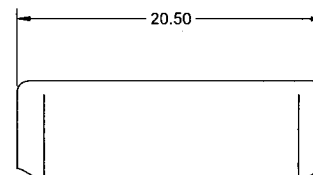
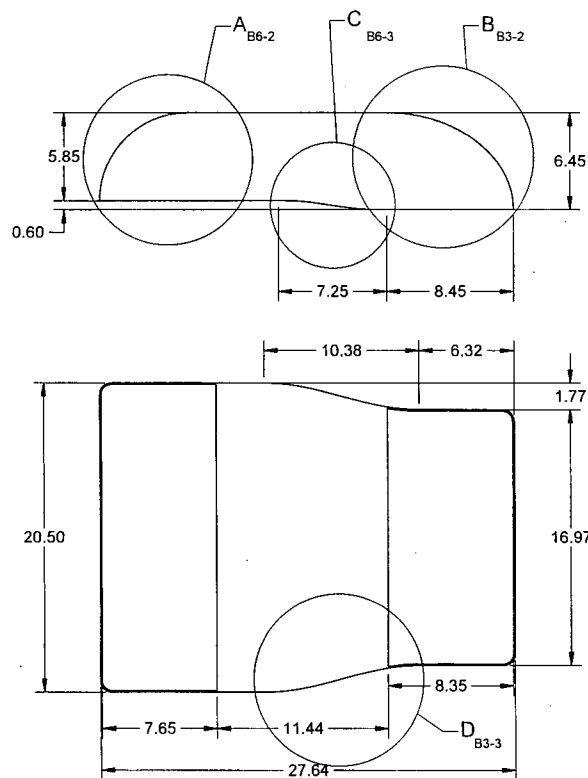
**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.64"	± .030	27.62"	✓			
20.50	± .030	20.5"	✓			
16.97	± .030	16.95"	✓			
6.45	± .030	6.5"	✓			
5.89	± .030	5.875"	✓			

<b>Measured by:</b> Dh-	<b>Date:</b> 10/01/14
<b>Audited by:</b> S - to PR3 Dry only	<b>Date:</b> 11/01/14
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10-04-14



65393

# **D4315-1 INTAKE SCOOP**

**PRELIMINARY ISSUE**

11.01.05

## **NOTES:**

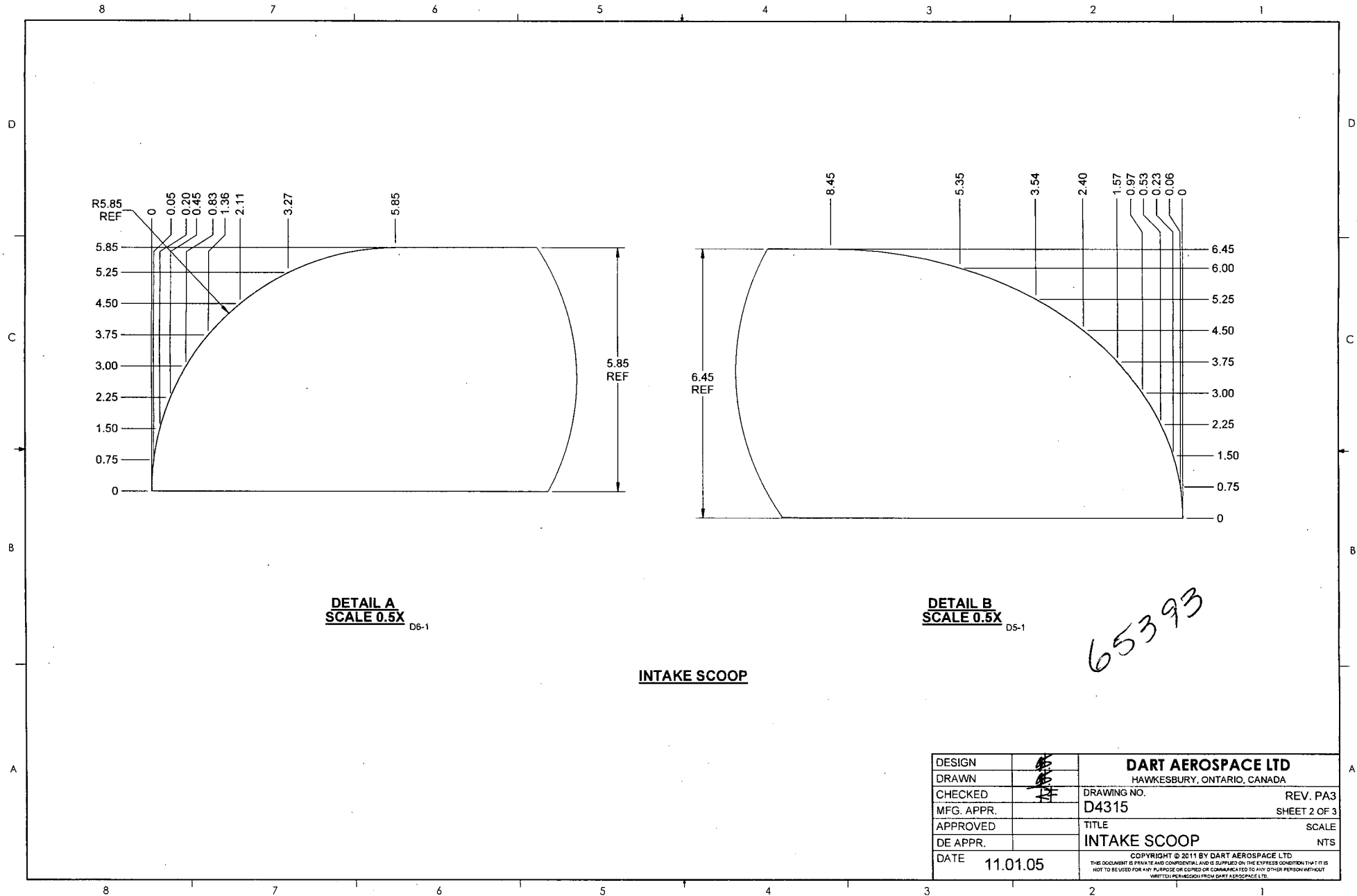
- 1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET, (HEAVY HAIRCELL/CORB TEXTURE), 0.125 THICK  
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.98 lbs
- 8) IT IS ACCEPTABLE FOR PART TO HAVE A 1.00 FLANGE AROUND PART AFTER THERMOFORMING
- 9) IT IS ACCEPTABLE FOR PART TO BE MADE IN TWO PIECES (UPPER BOWL PORTION AND LOWER FLAT PORTION)

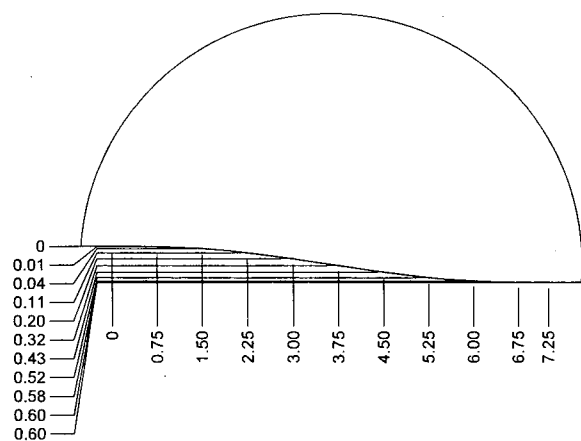
PA3	NEW ISSUE		11.01.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.01.05		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4315</b>	REV. PA3 SHEET 1 OF 3
TITLE <b>INTAKE SCOOP</b>	
SCALE NTS	
COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

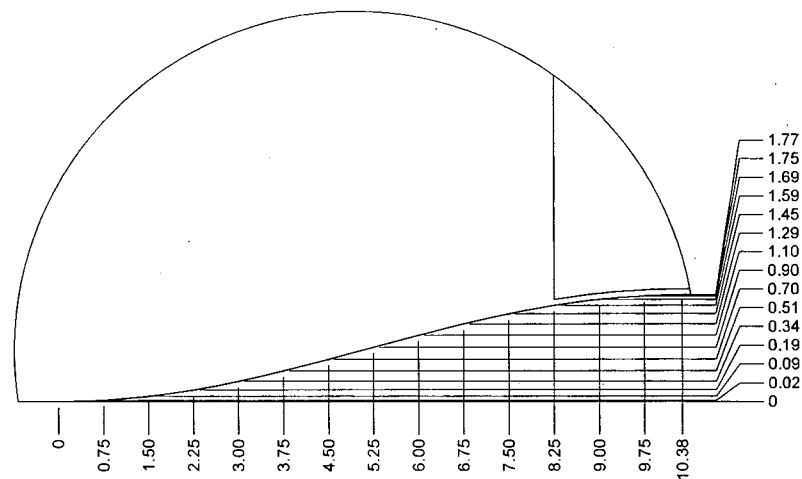






**DETAIL C**  
**SCALE 0.5X**

D6-1



**DETAIL D**  
**SCALE 0.5X**

B5-1

65393

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4315	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		INTAKE SCOOP	NTS
DATE	11.01.05	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	